



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D206-667-201
Job Sheet 197726



Part No: D206-667-201

Job Qty: 1 pcs

Part Name: Aft Crosstube - High 206 A/B



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/15/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/16/19

Description:

Note: DWG D206-667-241 REV C (DEO), DSI 9471 REV A IPP RevA: New issue DD verified by:EC IPP REV:B
11.08.08 PER ECN 11-615 DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Job Routing													
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off			
					Setup Hrs	Run Hrs	Workcenter / Supplier						
110	Packaging 1 - Pick Kit	1		8/16/19	0.00	0.00	Packaging 1 - 1			DAS			
NOT REQUIRED										Packaging 1 - 2		45	19-7-17
										Packaging 1 - 3			
										Packaging 1 - 4			
										Packaging 1 - 5			
										Packaging 1 - 6			
										Packaging 1 - 7			
										Packaging 1 - 8			
										Packaging 1 - 9			
										Packaging 1 - 10			
										Packaging 1 - 11			
										Packaging 1 - 12			
										Packaging 1 - 13			
										Packaging 1 - 14			
										Packaging 1 - 15			
										Packaging 1 - 16			
										Packaging 1 - 17			
										Packaging 1 - 18			
										Packaging 1 - 19			
										Packaging 1 - 20			
										Packaging 1 - 21			
										Packaging 1 - 22			
										Packaging 1 - 23			
										Packaging 1 - 24			
										Packaging 1 - 25			
										Packaging 1 - 26			
										Packaging 1 - 27			
										Packaging 1 - 28			
										Packaging 1 - 29			
										Packaging 1 - 30			

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[Dart Hawkesbury] Job Sheet - Lajeunesse, Mane

				Packaging 1 - 31		
				Packaging 1 - 32		
				Packaging 1 - 33		
				Packaging 1 - 34		
				Packaging 1 - 35		
				Packaging 1 - 36		
120	Crosstubes - Bend - 2 - B4B	1 pcs	8/16/19	0.50 2.76	Crosstubes - Bend - B4B	GP/BB 06/14/19
130	QC 15	1 pcs	8/16/19	0.00 0.00	QC 15 - 12	
				QC 15 - 3		
				QC 15 - 47		
				QC 15 - 49		
				QC 15 - 58		
				QC 15 - 9		
				QC 15 - 68		
140	Crosstubes - 2 - B4B	1 pcs	8/16/19	0.00 1.11	Crosstubes - 1 - B4B	GP 19-08-07
				Crosstubes - 2 - B4B		
				Crosstubes - 3 - B4B		
				Crosstubes - 4 - B4B		
150	Crosstubes - 3 - B4B	1 pcs	8/16/19	0.00 0.40	Crosstubes - 1 - B4B	GP 19-08-07
				Crosstubes - 2 - B4B		
				Crosstubes - 3 - B4B		
				Crosstubes - 4 - B4B		
160	QC 5	1 pcs	8/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
170	QC 7	1 pcs	8/16/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13		
				QC 7 - 14		
				QC 7 - 15		
				QC 7 - 17		
				QC 7 - 18		
				QC 7 - 19		
				QC 7 - 2		
				QC 7 - 28		
				QC 7 - 3		
				QC 7 - 30		
				QC 7 - 34		
				QC 7 - 36		
				QC 7 - 37		
				QC 7 - 41		
				QC 7 - 47		
				QC 7 - 48		
						DAS AUG 12 2019 68 9-89
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[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	AUG 12 2019
					QC 7 - 50	DAS 68 9-89
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
180	Outsource - 2 - NDT per QSI038	1 pcs	8/16/19		SKY002-VC	2019-08-13
190	Packaging 2-1 - Receive - B4B	1 pcs	8/16/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
200	QC 6	1 pcs	8/16/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
210	Spray Paint - 2 - B4B	1 pcs	8/16/19	0.00 0.25	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	

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220 QC 14	1 pcs	8/16/19	0.00 0.00	Spray Paint - 4 - B4B	
				QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
230 Crosstubes - 4 - B4B	1 pcs	8/16/19	0.00 1.11	Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	
240 QC 5	1 pcs	8/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
250 Packaging 1-2 - Pick Kit - B4B	1 pcs	8/16/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	

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				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260 QC 4	1 pcs	8/16/19	0.00 0.00 x	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
270 Packaging 3-1 - Stock - B4B	1 pcs	8/16/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	

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275 DC - 1 - B4B	1 pcs	8/16/19	0.00 0.00	Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
280 QC 21 - FG	1 pcs	8/16/19	0.00 0.00	DC - 1 - B4B	21
				DC - 2 - B4B	9-53 NOV 13 2019
				QC 21 - FG - 21	
				QC 21 - FG - 70	DAS
				QC 21 - SA - 53	21 NOV 13 2019

Part Op 110 Pick Kit

Descriptions: (CNC Alpha 160 Bender), Bend tube as per Dwg D206-667-241 using CNC bender program 206B-AF and Folio

130 - QC15- Crosstube Dimensional Check

140 - 1Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576 2-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576. (DRILL 3 HOLES ON BOTH SIDES) 3-Flip tube and switch drilling Jigs from right to left, left to right. Locate tube using "T" pins off holes drilled in previous step. 4-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576 5-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576. Check dimensions between holes on all four sides to ensure proper alignment. Use DT8583 & 8584 SUPPORT Jigs. (DRILL 3 HOLES ON BOTH SIDES) 6-Drill rivet holes as per Dwg D206-667-241 using drill Jig DT8788 7-C/sink holes as per Dwg D206-667-241 8-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr & inspect for surface damage. Repair damage within limits as per Dwg D206-667-241 9-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-241 Inside of Cuff (Do n

150 - (Crosstubes Chemical Conversion), ***IMMEDIATELY AFTER GRINDING*** 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT AS PER QSI005.

160 - QC5- Inspect part completeness to step on W/O

170 - QC7-Inspect Chemical Conversion Coat

180 - (Outsource process - NDT per QSI038 4.1), *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

190 - (Receive & Inspect for Damage & Mat'l Certs), *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order.

200 - QC6- All purchased or subcontracted products *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D206-667-201

210 - (Spray Paint / NDT Room), Spray Painting per QSI005 4.2 ***VERIFY BY _____ BATCH # TO MATCH W/O ***VERIFY BY _____ PART # TO MATCH W/O ***MASK SCRIBE

B# & P# AND VERIFY*** 1-Mask holes 2-Prime inside and outside crosstube as per QSI 005 4.2 3-Paint outside crosstube with White Imron as per QSI 005 4.2 PRIME: Start Time: 5:18:22 Finish Time: 5:20:42 PAINT: Start Time: 5:20:42 Finish Time: 5:20:42

220 - QC14- Inspect Spray Paint Wrap in plastic bag to protect from scratches ***VERIFY BY _____ BATCH # TO MATCH W/O ***VERIFY BY _____ PART # TO MATCH W/O

230 - INSTALL GROUNDING CLAMP AND SEAL WITH SIKAFLEX AS PER DWG AND DEO A/R SIKAFLEX BATCH: _____

1-Abraze mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2-Install supports with Proseal 890 per D206-667-141 (DEO) and QSI 015 A/R Proseal 890 Batch: 8176610 EXP: 19/10 3-Install supports clamps Using Dt9565 as per Dwg D206-667-141 (DEO), Torque to 80-100 IN-LBS. PROSEAL CURE TIME 72 HOURS: Start: 19-8-17 Finish: 19-8-20

240 - (QC5- Inspect part completeness to step on W/O), ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.*** ***VERIFY BY _____ BATCH # TO MATCH W/O ***VERIFY BY _____ PART # TO MATCH W/O

250 - Pick Kit

260 - QC4- 100% Inspect kits for completeness ***VERIFY BY _____ BATCH # TO MATCH W/O ***VERIFY BY _____ PART # TO MATCH W/O

270 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPPD206-667-201 Location : FG103

275 - Document Control Photocopy bluefile and create labels as per PPP D206-667-201 CHG004

280 - QC21- Final Inspection - Work Order Release

011536

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D206-667-201TRN	Crosstube Turning Detail	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	B140413
D2891-1	Support 2.25	2 pcs (2 ea)	230-Crosstubes - 4 - B4B	
D3595-063-395	Rubber Cushion 0.63" Wide X 3.95" Long	4 pcs (4 ea)	230-Crosstubes - 4 - B4B	
MS21920-20	Clamp	4 Ea (4 ea)	230-Crosstubes - 4 - B4B	
AN5-10A	Bolt	10 Ea (10 ea)	250-Packaging 1-2 - Pick Kit - B4B	5205280
AN5-30A	Bolt	10 Ea (10 ea)	250-Packaging 1-2 - Pick Kit - B4B	5166080
AN5-32A	Bolt	4 Ea (4 ea)	250-Packaging 1-2 - Pick Kit - B4B	5058983
D2872-043	Nut Plate Assembly	2 pcs (2 ea)	250-Packaging 1-2 - Pick Kit - B4B	5111038
D2872-045	Nut Plate Assembly	2 pcs (2 ea)	250-Packaging 1-2 - Pick Kit - B4B	5130416
D3038-3	Centre Drill	1 pcs (1 ea)	250-Packaging 1-2 - Pick Kit - B4B	5217881
MS21042L5	Nut	10 Ea (10 ea)	250-Packaging 1-2 - Pick Kit - B4B	5160302
NAS1149D05631	Washer	20 Ea (20 ea)	250-Packaging 1-2 - Pick Kit - B4B	5134697

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick'Kit 230-Crosstubes - 4 - B4B	D206-667-201TRN	1	4	0
	D2891-1	2 5176244	10	0
	D3595-063-395	4 5190524	39	0
	MS21920-20	4 5103843	67	0
250-Packaging 1-2 - Pick Kit - B4B	AN5-10A	10	82	0
	AN5-30A	10	28	0
	AN5-32A	4	277	0
	D2872-043	2	0	0
	D2872-045	2	0	0
	D3039-3	1	0	0
	MS21042L5	10	401	0
	NAS1149D0563J	20	2,158	0
Part Specifications				
Specifications could not be found.				

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Item	Qty	Part Number	Description
1	X	D208-667-241	CROSSTUBE ASSEMBLY (2088 HIGH AFT)
2	1	D6003-102	CROSSTUBE
3	2	D2891-1	SUPPORT
4	4	D3595-063-395	RUBBER CUSHION
5	4	MS21920-20	CLAMP (FOR MS21920-21)
6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRONBELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6003-102 FINISHED LENGTH = 100.60±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D208-667-241" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 22.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 008.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS MECHANISMS ARE LOCATED ON CROSSTUBE CLAMPS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 90 TO 100 N-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

UNDER REVIEW

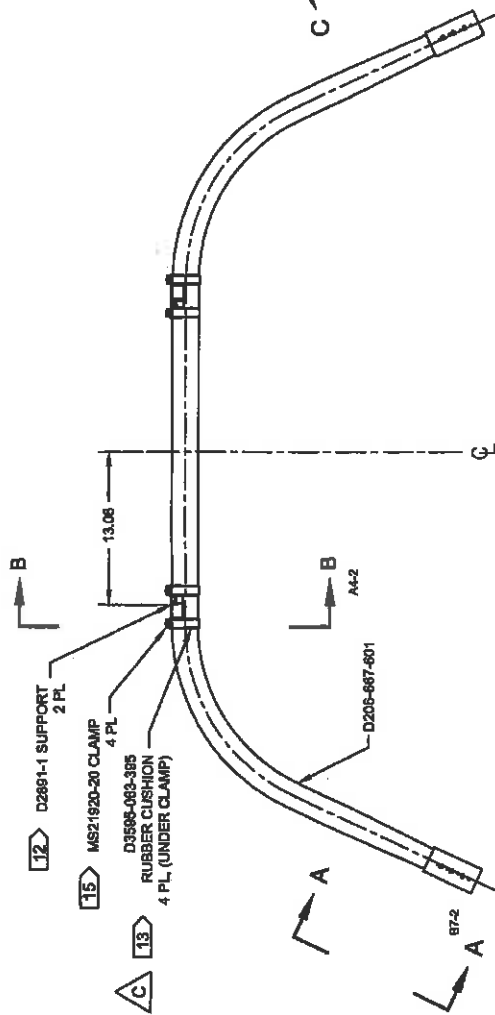
OK 08/11/06

RELEASED
08/11/2006

DEO ATTACHED

C		REFORMAT/REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2891-100-064 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C6-3, C4-3, D3-3); RELOCATED FLAG #6 (ZN A7-9) PER NCR 270; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.		RF	08.11.06
B		ADD HOLES FOR COMPATIBILITY WITH BRT/AA SKIDTUBES		PH	05.02.04
A		NEW ISSUE		CP	00.11.17
REV.		DESCRIPTION		BY	DATE
DESIGN	0				
DRAWN	0				
CHECKED	0				
MFG. APPR.	0				
APPROVED	0				
DE APPR.	0				
DATE	08.11.06				
		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C	
		DRAWING NO. D208-667-241		SHEET 1 OF 4	
		TITLE CROSSTUBE ASSY (2088 HIGH AFT)		SCALE	
				NTS	
				COPYRIGHT © 2006 BY DART AEROSPACE LTD.	
				ALL RIGHTS RESERVED. NO PART OF THIS PUBLICATION MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.	

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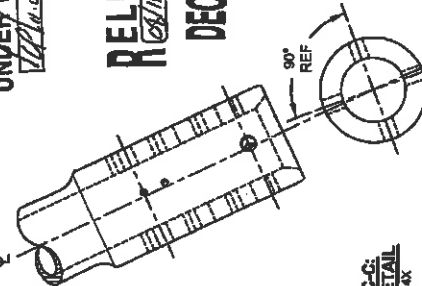


D208-667-241
ASSEMBLY DETAIL
(VIEW LOOKING FWD)

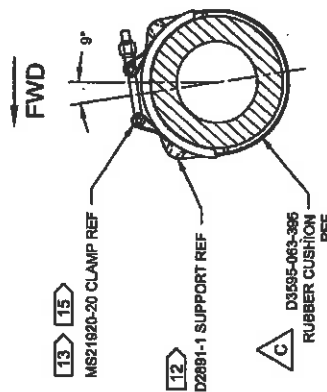
UNDER REVIEW
11/11/13 OK d.h. 100

RELEASED
R 08/11/12/11/12

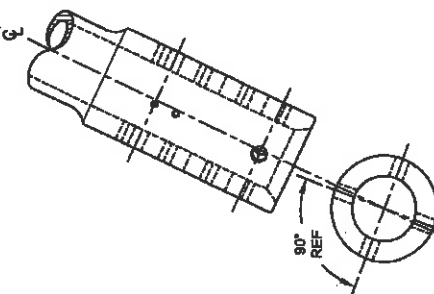
DEO ATTACHED



VIEW C-C:
CUFF DETAIL
SCALE 4X



SECTION B-B
SCALE 5X



VIEW A-A:
CUFF DETAIL
SCALE 4X

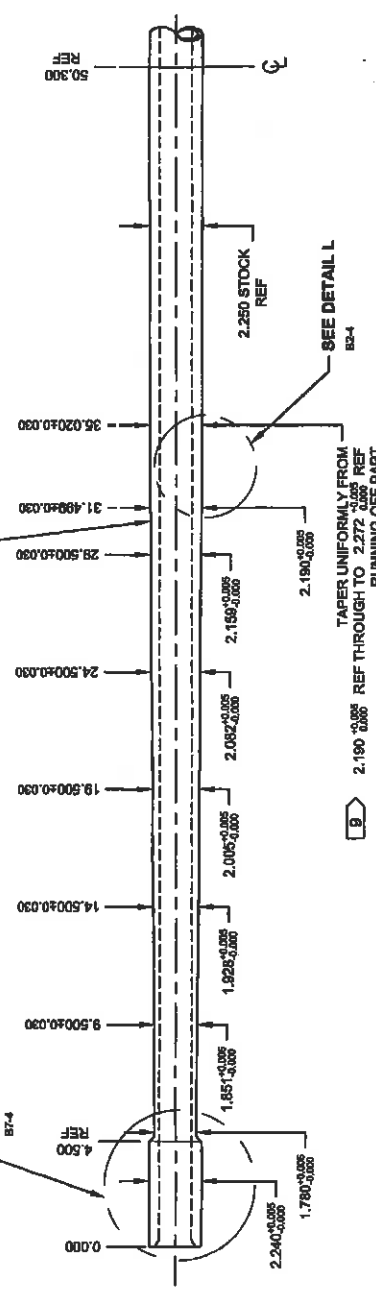
DESIGN			DART AEROSPACE LTD
DRAWN	RF		HAWKESBURY, ONTARIO, CANADA
CHECKED	RF		DRAWING NO.
MFG. APPR.			D208-667-241
APPROVED			TITLE
DE APPR.			CROSSTUBE ASSY (208B HIGH AFT)
DATE	08.11.06		SCALE
			NTS

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1 2 3 4 5 6 7 8

R100.0 TRANSITION
BETWEEN TAPERED
SECTIONS

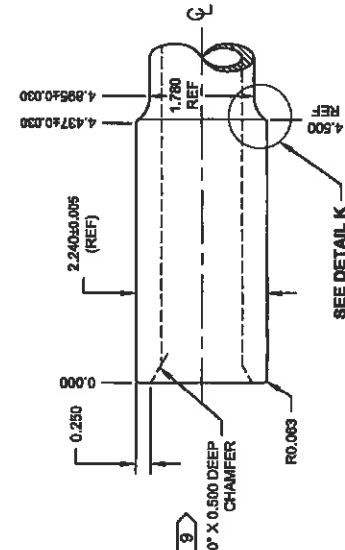
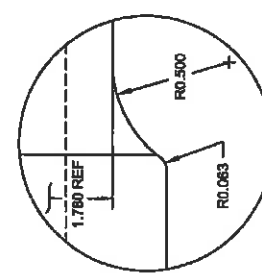
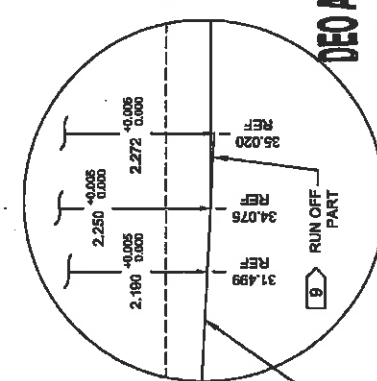
SEE DETAIL J
B7-4



TAPER UNIFORMLY FROM
2.272 ± 0.005 REF
RUNNING OFF PART

B 2.190 ± 0.005

TURNING DETAIL
C



SEE DETAIL K
B4-4

DETAIL J:
CROSSTUBE CUFF
NOT TO SCALE

DETAIL K:
CUFF TRANSITION
NOT TO SCALE

DETAIL L:
TAPER RUN-OFF
NOT TO SCALE

DEO ATTACHED
RELEASED
R 08/11/12

UNDER REVIEW
08/11/12

DESIGN	0	REF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
DRAWN	0	0		
CHECKED	0	0	DRAWING NO.	SHEET 4 OF 4
MFG. APPR.	0	0	D206-867-241	SCALE
APPROVED	0	0	TITLE	CROSSTUBE ASSY (206B HIGH AFT)
DE APPR.	0	0		NTS
DATE	08.11.06			

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DRAWING NO. D206-667-241	TITLE CROSSTUBE ASSY (206B HIGH AFT)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D206-667-241-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 90	CHECKED AS		MFG. APPR. M	APPROVED M		DE APPR. M	
DATE 11.07.15	DATE 11.08.22		DATE 11.08.22	DATE 11.08.22		DATE 11.08.22	

PURPOSE:
REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty	Part Number	Description
6	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	----------------	---

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

12) TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

WAS:

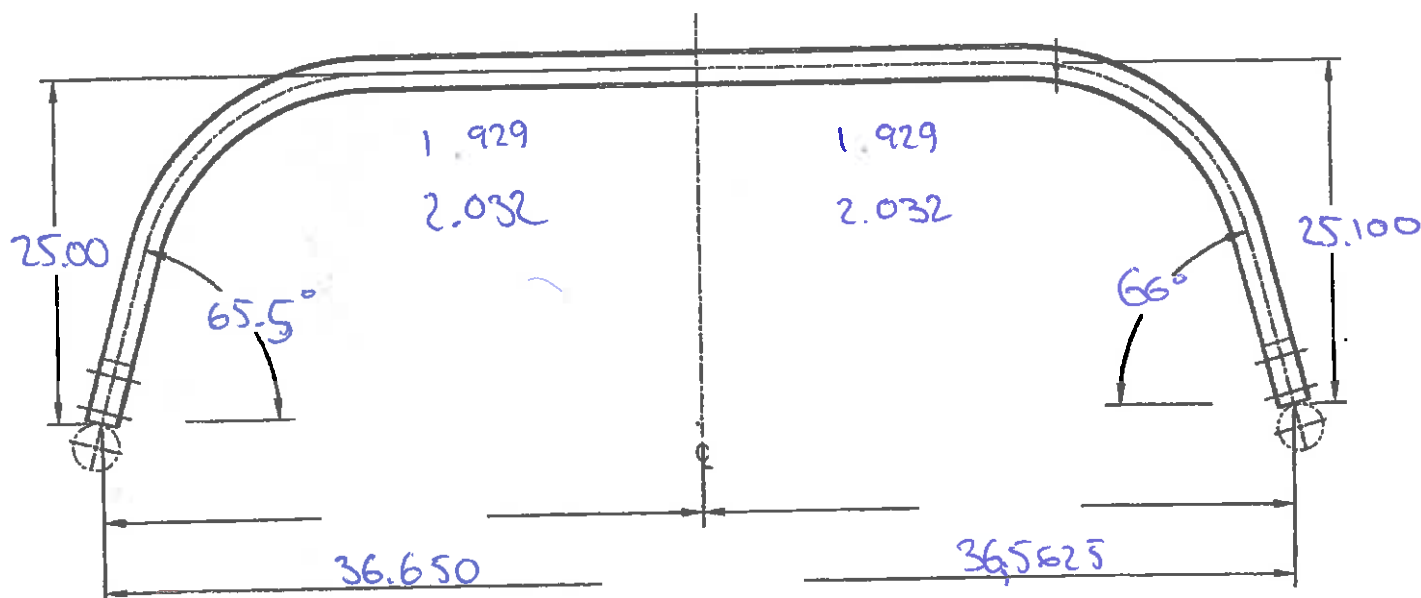
12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-08-23
M

DART AEROSPACE LTD	Work Order:	
Description: Crossstube High Aft (206B)	Part Number:	D206-667-201
Inspection Dwg: D206-667-241	Rev: C	Page 1 of 1

Required Dimension	Min	Max
Height	24.91	25.17
1/2 Span	36.47	36.73
Angle	65	67
Total Span	72.95	73.45
Bending Passes	12	—
Crushing	—	6%



	Side A	Side B
Bending Passes	12	12
Crushing	2.4%	2.4%
Comments		

QC15 Inspection	<i>[Signature]</i>
Date	19-07-18

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.12.04	24.98 was 24.48	KJ/JM	
C	11.10.12	Dimensions updated per Dwg Rev C	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	<i>[Signature]</i>



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044239



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044239

PO Date: 8/12/19

Due Date: 8/13/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197937	D119-796-251	Aft Crosstube Installation With Step (No Hardware) : TC STC SH14-45-Issue 1, FAA STC SR03504NY 15/01/28, EASA STC 10052022 Revision 1 15/02/13, DGCA INDIA LoA 07-09/2011-AED (Part) 15/07/16, BRAZIL STC 2015S07-16 15/07/30, CAAP PHILIPPINES LoA 16/05/11, CHINA VSTC0757 16/07/22, RUSSIA STC CT316-A119 16/08/11, DGAC INDONESIA STC SR025 18/02/19 ISSUE P/O: *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** C OF C IS REQUIRED	Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	197938			Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

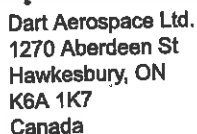
PURCHASE ORDER

POHB044239



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	197723	D206-667-203	Aft Crosstube - High 206L / L1 / L3 / L4 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 (Outsource process - NDT per QSI038 4.1), *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Issue P/O: _____ LPI as per ASTM 1417	Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	197724			Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00
3	197725	D206-667-201	Aft Crosstube - High 206 A/B : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 (Outsource process - NDT per QSI038 4.1), *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	197726			Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00
4	196763	D130-1048-041	H130/EC130 - Replacement Skldtube - Standard - LH : TC STC SH19-4 Issue 1, FAA STC SR04320NY dated 19/03/26 (Outsource process - NDT per QSI038 4.1), ISSUE P/O: _____ Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED	Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	196762			Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00

Plex 8/13/19 1:55 PM Dart.Guerin.Kimberley



PURCHASE ORDER
POHB044239



Grand Total: \$1,195.00

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/13/19 1:55 PM Dart.Guerin.Kimberley

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO41392	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB044239
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

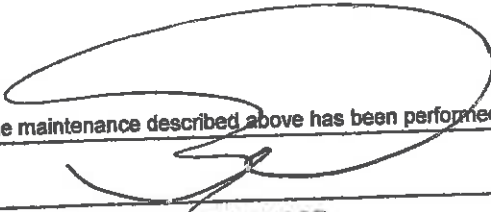
Work Required:**CARRY OUT NDT ON:**

- ✓ 2 REPLACEMENT SKIDTUBE-STANDARD-LH, P/N: D130-1048-041, J/S: 196762, 196763
- ✓ 2 REPLACEMENT SKIDTUBE-STANDARD-RH, P/N: D130-1048-042, J/S: 196766, 196767
- ✓ 2 AFT CROSSTUBES, P/N D119-796-251, J/S: 197937, 197938
- ✓ 2 AFT CROSSTUBES, P/N: D206-667-203, J/S: 197723, 197724
- ✓ 2 AFT CROSSTUBES, P/N: D206-667-201, J/S: 197725, 197726

DAS
40
9-89

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16 NO CRACK FOUND PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923, DEV. MPO11715 , UV LIGHT M-20142						AUG 13 2019	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: AUG 13 2019
Name: RAFIK MELIKIAN		

5.0 PARTS LIST

5.1 HIGH GEAR CROSSTUBES

Item	Qty -101	Qty -201	Qty -103	Qty -203	Qty -105	Qty -205	Part Number	Description
	X						D206-667-101	CROSSTUBE INSTALLATION, 206A/B HIGH FWD
		X					D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
			X				D206-667-103	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD
				X			D206-667-203	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT
					X		D407-667-105	CROSSTUBE INSTALLATION, 407 HIGH FWD
						X	D407-667-205	CROSSTUBE INSTALLATION, 407 HIGH AFT
1	1						D206-667-141	CROSSTUBE ASSEMBLY, 206A/B HIGH FWD
2		1					D206-667-241	CROSSTUBE ASSEMBLY, 206A/B HIGH AFT
3			1				D206-667-143	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD
4				1			D206-667-243	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT
5					1		D407-667-145	CROSSTUBE ASSEMBLY, 407 HIGH FWD
6						1	D407-667-245	CROSSTUBE ASSEMBLY, 407 HIGH AFT
10	*2	*2	*2		*2		D2891-1	SUPPORT
11				*2			D2892-1	SUPPORT
12						*1	D2894-1	SUPPORT
13	*4	*4	*4		*4		D3595-063-395	RUBBER CUSHION
14				*4			D3595-063-450	RUBBER CUSHION
15						*2	D3595-075-430	RUBBER CUSHION
16	*4	*4	*4		*4		MS21920-20	CLAMP
17				*4		*4	MS21920-22	CLAMP
18						*2	MS21920-25	CLAMP (OR MS21920-24)
19	4	4	4		4		AN5-32A	BOLT
20				4		4	AN5-34A	BOLT
21	4	4	4	4	4	4	MS21042L5	NUT (OR MS21042-5)
22	8	8	8	8	8	8	NAS1149C0563J	WASHER (OR AN960JD516)
23						*2	D3190-1	CHAFING SHIELD
40	*2		*2	*2	*2	*2	D2873-043	NUT PLATE
41	*2		*2	*2	*2	*2	D2873-045	NUT PLATE
42		2					D2872-043	NUT PLATE
43		2					D2872-045	NUT PLATE
44	10		10				AN5-7A	BOLT
45		10		10	10	10	AN5-10A	BOLT
46	4	10	4		4		AN5-30A	BOLT
47				4		4	AN5-32A	BOLT
48			12				AN970-4	WASHER (OPTIONAL)
49		6					MS21042L5	NUT (OR MS21042-5)
50	10	12	10	10	10	10	NAS1149C0563J	WASHER (OR AN960JD516)
60		1					D3039-3	CENTER DRILL (TOOLING, NOT INSTALLED)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/-143/-241/-243 & D407-667-145/-245
ASSEMBLIES ABOVE

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Revision: D

Date: 11.05.01